

Work Order ID 134162

Friday, July 03, 2015 3:46:40 PM

134162

Page 1

Item ID: D3180-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Assembly, RH
 Start Date: 7/03/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/03/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: JUL 06 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3180	C

100	NC BRAKE	0.00				2	FF	JUL 06 2015
100								
Brake NC	Memo	0.02						
Brake NC	1-Punch Tubing to length as per Dwg D3180-2 using DT8313, DWG D2638							

110	Small Fab	0.00				2	FF	JUL 06 2015
110								
Small Fab	Memo	0.05						
Small Fab	1-Drill holes as per Dwg D3180							
	2-Bend strut as per Dwg D3180							
	3-Deburr edges							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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OTHER : ☐									

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Stop *NS2*

Customer:

Reference:

Stop ***NR2***

150

Small Fab

0.00

Small Fab

Memo

0.02

Small Fab

1-Assemble as per Dwg D3180

160

QC5- Inspect part completeness to step on W/O	0.00
---	------

0.00

QC

Memo

Quality Control

170

Identify as per dwg & Stock Location: St. 361 0.00

0.00

Packaging

Memo

Packaging

2 FF JUL 14 2015

② 15-07-17

27
9-89

JUL 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 134162***134162***

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Revision ID: Stop ***NS2***
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

SH
15/7/21

MCS
JUL 2 2 2015

MCS
JUL 2 1 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong															
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions															
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance															
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect															
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing															
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Past Expiry Date ☐	☐	Manufacturing Process	OTHER :																						
Misidentified ☐	☐	Past Due																							

Picklist Print

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Work Order ID: 134162

134162

Parent Item: D3180-042

D3180-042

Parent Item Name: Strut Assembly, RH

Start Date: 7/03/15

Required Date: 7/03/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.04.11 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6		Manufactured	No				Each	32.0000		2			
D2690-6									**				
Lanyard													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST009				32					
				132746				20		2			
				133506				2					
				134004				10					
M304TR0.750W.065		Purchased	No				f	174.0000		7.543789			
M304TR0 750W 065									**				
304 RD Tube .750 x .065W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA002				174					
				114002				10					
				118390				2					
				<u>m129493</u>				162					
D2022-101		Manufactured	No				Each	194.0000		4			
D2022-101									**				
Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST002				93					
				107903				80					
				<u>129976</u>				13		2			
				ST012a				101					
				132703				101					

FF JUL 06 2015

FF JUL 06 2015

FF JUL 06 2015

7.543789

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Friday, July 03, 2015 3:46:40 PM

Work Order ID: 134162

134162

Parent Item: D3180-042

D3180-042

Parent Item Name: Strut Assembly, RH

Start Date: 7/03/15

Required Date: 7/03/15

Start Qty: 2.00

Required Qty: 2.00

A1449

Purchased

No

Each

1,067.000

2

A1449

Grommet

**

FF

JUL 06 2015

Location

Loc Qty

Loc Code

ST548

1067

1487

1067

2

MS17984-C310

Purchased

No

Each

1.0000

2

MS17984-C310

Quick Release Pin

**

FF

JUL 14 2015

Location

Loc Qty

Loc Code

ST315

1

132699

1

2

m130953

MS21042L3

Purchased

No

Each

1,618.000

2

MS21042L3

Nut

**

FF

JUL 08 2015

Location

Loc Qty

Loc Code

FP001

393

134113

M130922

393

GA

440

M131317

440

ST305

785

116549

12

126333

49

M128754

2

M132123

17

M132382

705

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Shop Packet Print

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DQA: _____ Date: _____



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D3180-042

Parent Item Name: Strut Assembly, RH

Start Date: 7/03/15

Required Date: 7/03/15

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-10

Purchased

No

Each

489.0000

2

JUL 06 2015

MS27039-1-10

FF

SCREW

Location

Loc Qty

Loc Code

CA

41

m128635

41

GA

238

m129541

238

2

ST285

210

m123522

2

m130358

8

m132640

200

NAS1149D0363J

Purchased

No

Each

1,303.000

6

JUL 06 2015

NAS1149D0363.J

FF

Washer

Location

Loc Qty

Loc Code

CA

569

m130799

569

6

GA

134

m128429

134

ST269

600

2799

4

6140

8

m126319

7

m131618

17

m132317

564

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Misidentified ☐	Past Due ☐								

